

Date

Thursday, 5/10/2007 2:23:46 PM

User: Kim Johnston

**Process Sheet** 

**Drawing Name** 

Part Number

**Material** 

**Due Date** 

**Drawing Number** 

Project Number

**Drawing Revision** 

: GASKET

: D353625

: N/A

:NA

: 5/17/2007

: A

D3536 REV A

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 32271

**Estimate Number** 

: 12719

P.O. Number

:NIA

This Issue Prsht Rev.

First Issue

Written By

Comment

Previous Run

: 5/10/2007

: NC

S.O. No. : 1/1A

Type : SMALL /MED FAB

: Est Rev:A

New Issue 07-02-14 JLM

Qty:

4 Um:

Each

**Additional Product** 

Checked & Approved By

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

MNEO60S063

NEOPRENE SHEET 0.063



Comment: Qty.:

0.6254 sf(s)/Unit Total:

2.5015 sf(s)

**NEOPRENE SHEET 0.063** 

M103104 Batch:

63/05/12

2.0

WATER JET

FLOW WATER JET



Comment: FI OW WATER JET

1-Cut as per Dwg D3536

Dwg Rev:\_\_\_

Prog Rev:\_

SAN

GAD 0765/12

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

QC8

SECOND CHECK





Comment: SECOND CHECK

PACKAGING RESOURCE #1



5.0

PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Aerospa	ce	Ltd
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W/O:				WC	RK ORDER CHANG	ES				
DATE	STEP		PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	):	PAR	#:	Fault Categ	jory:	_ NCR: Yes	NO DQ	A: 🗀	Date: <u>c</u>	7/05/H
							N/C Close			
NCR:			V	VORK ORDE	R NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of	NC		Corrective Action Section		Verification		Approval	Approval
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NOTE: Date & initial all entries

,Date:

Thursday, 5/10/2007 2:23:46 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Part Number: D353625

Job Number: 32271

Seq. #:

Job Number:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

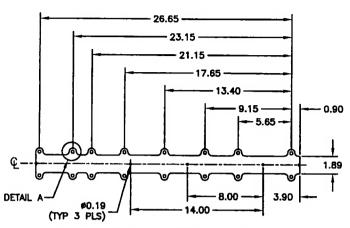


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<b>W</b> /O:			WC	ORK ORDER CHANG	ES			<del>- · · · · · · · · · · · · · · · · · · ·</del>
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
*								
Part No	):	PAR #:	Fault Cate	gory:	NCR: Yes	No DOA:	Date:	
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NCR:			WORK ORD	ER NON-CONFORMA			Date	
NCK.				Corrective Action Section				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approva QC Inspecto
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NOTE: Date & initial all entries



03.02.12

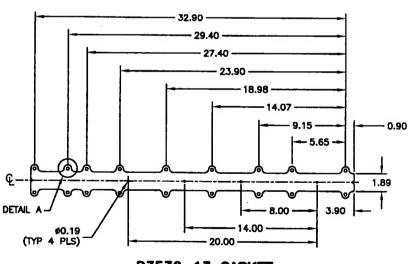


D3536-11 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT SHOP COPY WITHOUT NOTICE ENGINEERING RETURN TO

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE

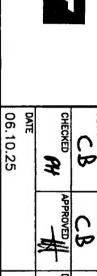
- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  7) SEE BACE & CONDITIONS AND OFFERDALE.
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

06.10.25 NEW ISSUE	06.10.25		Α
GASKET 1:10		06.10.25	90
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D3536 SHEET 1 OF 6	#	W	
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DART AFROSPACE USA INC.	DRAWN BY	) ?	DESIGN

07.02.12



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			DAKT AEROSPACE USA
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39.15 35.65 33.65 30.15 24.90 19.65 0.90 1.89 #0.19 (TYP 4 PLS) 3.90 DETAIL A 24.00

### D3536-15 GASKET

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PURPOSE

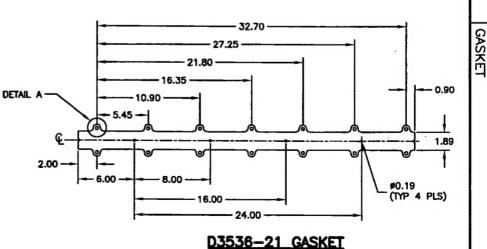
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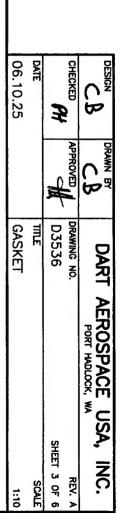
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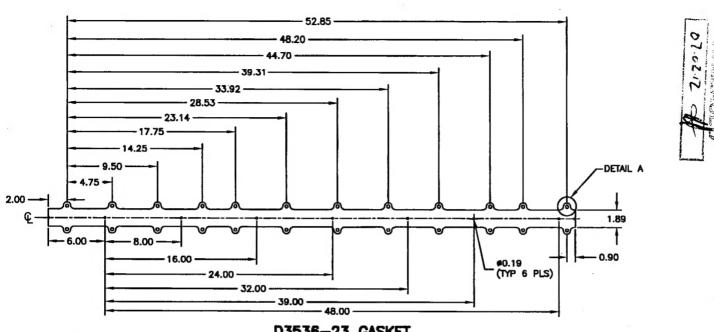
  1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
  DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
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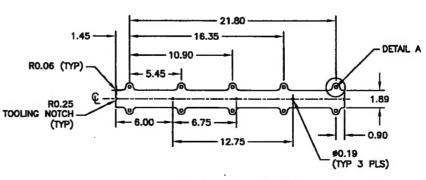
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT €
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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D3536-25 GASKET

PURPOSE

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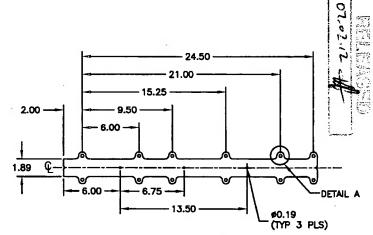
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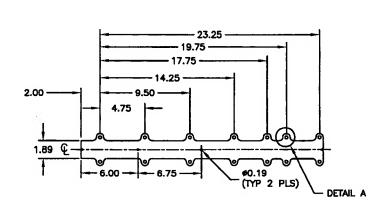
D3536-31 GASKET



D3536-33 GASKET



- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT ©
  TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
  IDENTIFY WITH DART P/N USING A WHITE FINE POINT
  PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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30.75 27.25 22.50 17.75 2.00 1.89 - 6.00 16.00 DETAIL A 21.00 #0.19 (TYP 4 PLS) D3536-37 GASKET

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PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOBO-S.063)

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2) FINISH: NONE

3) PART IS SYMMETRICAL ABOUT ©

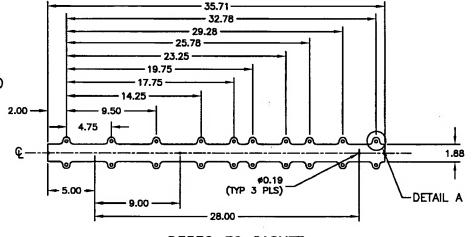
4) TOLERANCES ARE PER DART QSI D18 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

WITHOUT NOTICE

WORK ORDER

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D3536-39 GASKET

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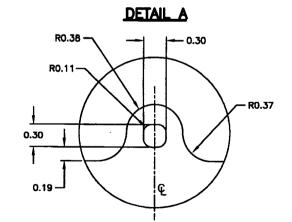
D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

DETAIL

- DUROMETER (REF DART SPEC. M-NEO6O-S
  2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
  PERMANENT INK MARKER

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1:10	GASKET		06.10.25	
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DART AEROSPACE USA, INC.	DART	CB	CB CB	

DART AEROSPACE LTD	Work Order:	32271
Description: Bearpaw GASKET	Part Number:	D373625
Inspection Dwg: D3536 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	spection Sheet wing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
А	21.80	+/-0.030	21,80	V		FR M-T	
В,	16.35	+/-0.080	16.35			W-T	
С	10.90	+/. 0.030	12,90			M-T	
D	5.45	+/-0.030	5.45			Vern	
Е	1.45	460.030	1,45			Vern	
F	6.00	4-6.030	6.01			Verg	
G	6.75	4/ 0.030	6.74		1.51	Vert	
Н	12.75	1/0.030	12,74	V		Vern	
1	0.90	1/2 0.030	0.91			Veun/neic	ht can
J	1.89	4.0.030	1,89			Vern)	18
K	0.30	+1.0.030	0.30			Vern	
L	0.30	4/-0.030	0.31			ven	
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Measured by: SAD	Audited by:	Prototype Approval:	N/A
Date: 07/05/12	Date: . 7.05.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.01.09	New Issue	KJ/RF	